



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3724-041

Job Sheet 174187



Part No: D3724-041

Job Qty: 1 ea

Part Name: Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A new issue 08-02-07 DD verified by:ec IPP Rev:B ecn1154p 08-03-13 DD verified by:ec IPP Rev:C ecn1158 08-03-19 DD verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/17/18	4/17/18	0.00	0.00	Start Up Large Fab-4		MS 2018-04-22
100	Large Fab	1 pcs	4/17/18	4/17/18	0.00	5.69	Large Fab 8		MS 2018-04-22
110	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC5		CPC
120	Large Fab	1 pcs	4/17/18	4/17/18	0.00	5.69	Large Fab 2		MS 2018-04-22
130	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC9		CPC
140	HandFinish	1 pcs	4/17/18	4/17/18	0.00	0.88	HandFinish1		MS 2018-04-23
150	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC7-2		CPC
160	Large Fab	1 pcs	4/17/18	4/17/18	0.00	5.69	Large Fab 8		MS 2018-04-23
170	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC10		CPC
180	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC5		CPC
190	HandFinish	1 pcs	4/17/18	4/17/18	0.00	0.88	HandFinish1		MS 2018-04-23
200	Powdercoat	1 pcs	4/17/18	4/17/18	0.00	0.26	Powdercoat1		BR 18-04-23
210	QC	1 pcs	4/17/18	4/17/18	0.00	0.00	QC3		BE 18-04-24
220	HandFinish	1 pcs	4/18/18	4/18/18	0.00	0.88	HandFinish2		BE 18-04-24
230	QC	1 pcs	4/18/18	4/18/18	0.00	0.00	QC5		38
240	Packaging	1 pcs	4/18/18	4/18/18	0.00	0.00	Packaging3-1		38
250	QC21-SA	1 Ea	4/18/18	4/18/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut D3737-1 as per dwg D3737 2-Cut D3738-1 as per dwg D3738 3-Debur and bevel ends for welding
 Descriptions: 120 - Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724 2-Grind flush
 160 - *****REMEMBER PAT DIMENSION ARE WITH THE END CAPS***** 1-Apply Magnobond before installing rivets
 A/R Magnobond 6398 Batch: M137073 2-Rivet D3741-1 and D3730-1 to brackets before installing on
 step as per dwg D3724 (RIVET HEAD MUST FACE FWD OF STEP) 3-Transfer holes from D3730-1 and D3741-1 into
 step as per dwg D3724 4-Debur 5-Apply magnabond as per dwg D3724 A/R Magnabond 6398 Batch: M137073
 6-Rivet brackets in place on step as per dwg D3724 7-Weld both end cap as per Dwg D3724 8-Grind end cap welds flush
 Inspect for foreign object per QSI 024
 190 - 1- Touch up with alodine
 200 - START TIME: 2:00 OVEN TEMPERATURE: 320° FINISH TIME: 3:00

M108760

wingwalk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3213-5-4	Cherry Rivet	32 Ea (32 ea)	90-Start up Operation	5038754
D2622-120C	Step Extrusion	1 Ea (1 ea)	120-Large Fab	5076116
D2734	Step End Plate	2 Ea (2 ea)	160-Large Fab	3012061
D3728-1	Step Bracket	3 Ea (3 ea)	160-Large Fab	5055913
D3729-1	Step Bracket	1 Ea (1 ea)	160-Large Fab	5055917
D3730-1	Angle	8 Ea (8 ea)	160-Large Fab	5062019
D3733-1	Gusset	1 Ea (1 ea)	160-Large Fab	5056261
D3741-1	Angle	8 Ea (8 ea)	160-Large Fab	5061690
MS20470AD5-11	Rivet	12 Ea (12 ea)	160-Large Fab	F107100-1
MS20470AD5-16	Rivet	4 Ea (4 ea)	160-Large Fab	F107100

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3213-5-4	32	99	0
120-Large Fab	D2622-120C	1	230	0
160-Large Fab	D2734	2	21	0
	D3728-1	3	0	0
	D3729-1	1	0	0
	D3730-1	8	0	0
	D3733-1	1	0	0
	D3741-1	8	0	0
	MS20470AD5-11	12	1,000	0
	MS20470AD5-16	4	687	0

Part Specifications

Specifications could not be found.



Container No: S051535



Part: D3724-041

Job No: 174187

Serial No/Batch: S051535

Revision:

Inspector:

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Plex 3/12/18 3:33 PM Dart.Gagnon.Michelle

001679

Date: 04/23/18

8

7

6

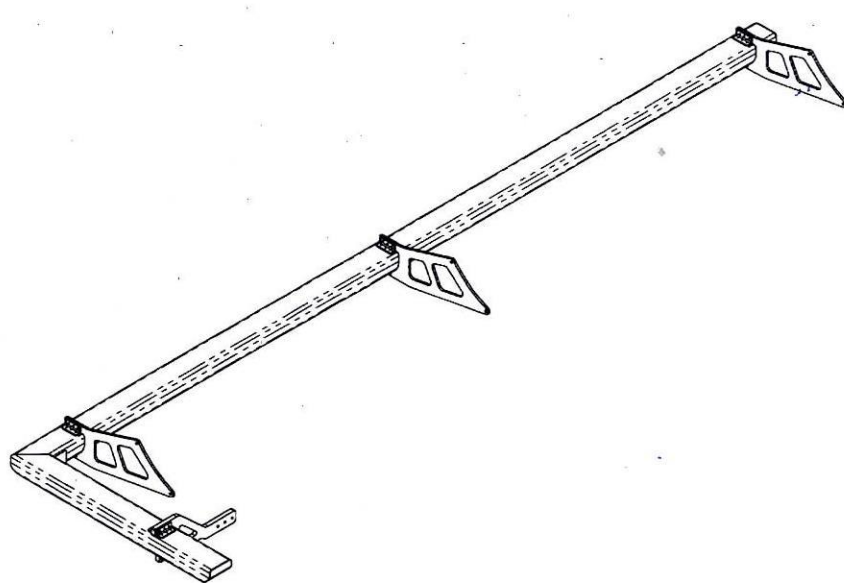
5

4

3

2

1



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE) / B

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.89 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
- 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22. 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	WLE		
MFG. APPR.	WLE		
APPROVED	WLE		
DE APPR.	WLE		
DATE	08.02.26		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3724** REV. B
 SHEET 1 OF 2
 TITLE **STEP ASSY**
 SCALE
 NTS

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